

Date: Tuesday, 10/23/2007 3:11:34 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: INLET WELDMENT (206)
Job Number	: 35335		
Estimate Number	: 10477		
P.O. Number	: <i>N/A</i>	Part Number	: D2413
This Issue	: 10/23/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2413 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 29312	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/6/2007 Qty: 4 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: C003.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2292	Heater Tube 4"
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Splice Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Heater Tube 4"

Qty	Part Number	Description	Batch
1	D2292	4" Ring	<i>B35339</i>

PD 07-10-31

2.0	D2405	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
End Plate

Qty	Part Number	Description	Batch
1	D2405	End Plate	<i>B26913 -> 2</i> <i>B15102 -> 2</i>

PD 07-10-31

3.0	D2407	3" Tubing
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Splice Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
3" Tubing

Qty	Part Number	Description	Batch
1	D2407	3" Tubing	<i>B35340 -> 1</i> <i>B25064 -> 3</i>

PD 07-10-31

4.0	D2408	Locator Cross
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Locator Cross

Qty	Part Number	Description	Batch
1	D2408	Locator Cross	<i>B26916</i>

PD 07-10-31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:11:34 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET WELDMENT (206)

Job Number: 35335

Part Number: D2413

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2409

Jet Pipe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Jet Pipe

4

Qty Part Number
1 D2409

Description
Jet Pipe

Batch

B25065-2

B26917-2

PD 07-10-31

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2413 Intake Assembly as per Dwg D2413 and QSI 004.

PD 07-10-31 (4)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07/10/31 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 07/11/01 (4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

BR 07-11-01 (4)

10.0

OUTSIDE SERV.15

OUTSIDE SERVICES - LF



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 4957

Red Anodize D2413 as per Dwg D2413

Possible Supplier: Anodizing TNM Paint

Ensure Certificate of Conformity is attached

C207/11/01

(4)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Anodize & Certs.

J 07/11/01 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 8/11/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:11:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET WELDMENT (206)

Job Number: 35335

Part Number: D2413

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

7-11-12 SP YX

13.0

AN8188D

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

1 AN818-8D

Flare Nut

M 19413 x 1

M 103641 x 3 FF 07-11-15

(4)

14.0

MS208198D

Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Sleeve

Pick:

Qty Part Number

Description

Batch

1 MS20819-8D

Sleeve

M 101840

FF 07-11-15

(4)

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2413. Sleeve & Flare tube as per Dwg D2413

FF 07-11-15

(4)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-11-16 (4)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 07-11-16

(4)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7-11-19

(4)

Job Completion



7-11-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2413	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995		TITLE 206 INLET WELDMENT SCALE	

RELEASED
96/09/10 BW

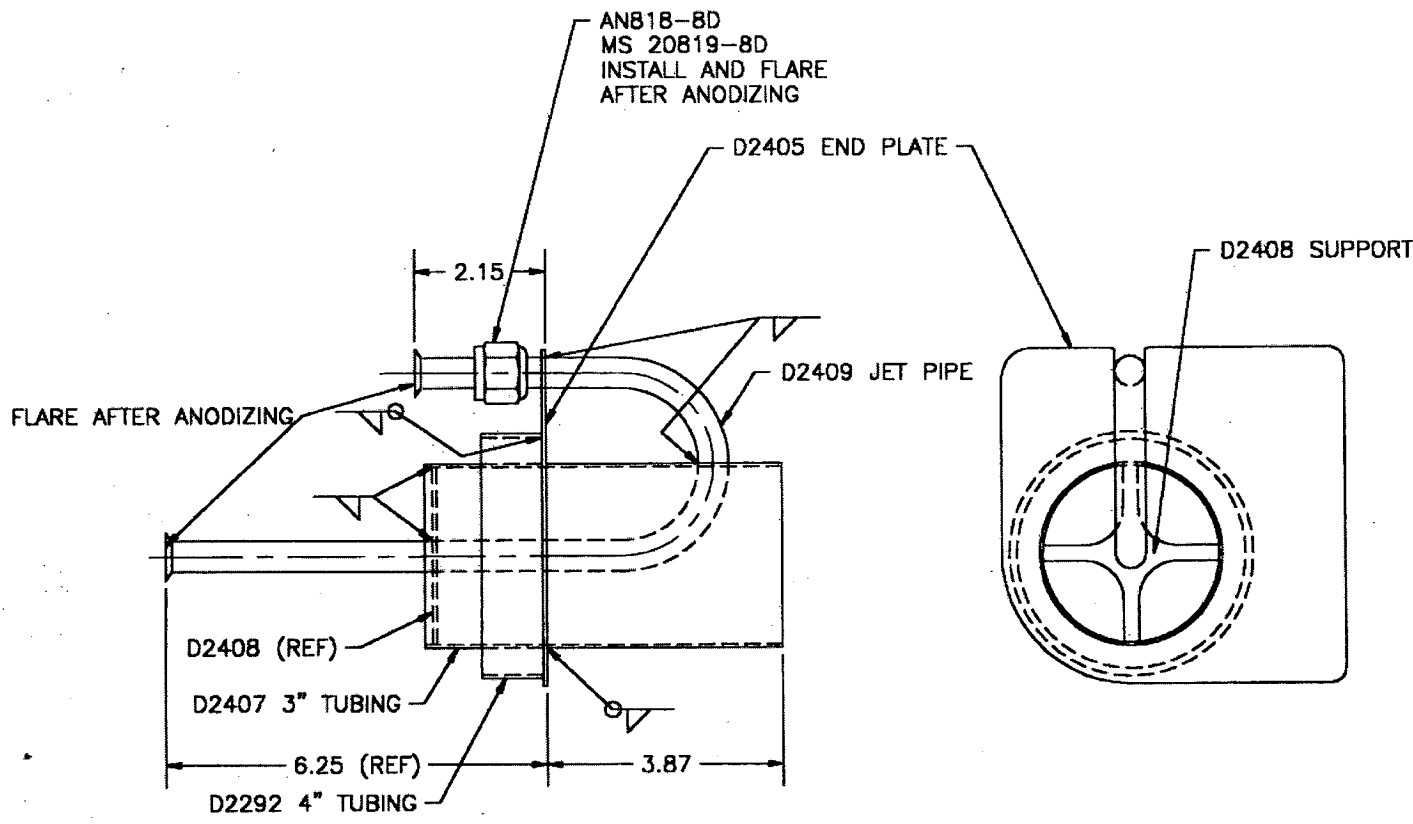
QTY	Part No.	Description
X	D2413	INTAKE WELDMENT ASSEMBLY
1	D2292	4" RING
1	D2405	END PLATE
1	D2407	3" TUBING
1	D2408	LOCATOR CROSS
1	D2409	JET PIPE
1	AN818-8D	FLARE NUT
1	MS20819-8D	SLEEVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35335



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BWS	APPROVED BWS	D2413	REV. A
DATE Apr. 6, 1995		TITLE 206 INLET WELDMENT	SHEET 2 OF 2
			SCALE

RELEASED
9609/10 (B4)



FINISH: ANODIZE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35335

VENTURE INM INC.

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

PACKING
SLIP

59970

09-Nov-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

PURCHASE ORDER/
NO. DE COMMANDE:

04957

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION
1	2	2	D2224B34970
1	4	4	D2413B35335
3	3	3	D2414B35336

PICKED UP BY / RECU: _____

En cas de perte ou de dommages dû à la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la
valeur du traitement des pieces perdues ou endommagées.
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

NM

ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, QC H9R 4Z2
 Telephone: (514) 429-7777 Fax: (514) 429-5108
 Certifié ISO 9001-2000 / ISO 9001-2000 certified
 Certifié NADCAP / NADCAP certified

**FACTURE
INVOICE**

59970 Rev.00

09-Nov-2007

CLIENT / CUSTOMER:

RT AEROSPACE LTD.

10 ABERDEEN STREET

WILKESBURY, ONTARIO

A1K7

**PURCHASE ORDER/
NO. DE COMMANDE: 04957**

CONDITIONS / TERMS:**NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
1	4	4	D2413B35335	\$0.00	\$0.00
3	3	3	D2414B35336	\$0.00	\$0.00
4	2	2	D2224B34970	\$0.00	\$0.00
			MINIMUM CHARGE		\$120.00
SUB TOTAL:					\$120.00
TPS/GST:					\$7.20
TVQ/PST:					\$0.00
TOTAL AMOUNT DUE:					\$127.20

No de TPS / GST #: 891559734 RT

No de TVQ / QST #: 1019307154 TQ000

**CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE
 CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS**

En cas de perte ou de dommages dû a la valeur intrinsèque de certaines responsabilit  se limitera   deux fois la valeur du traitement des pi ces perdues ou endommag es.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

59970

09-Nov-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

PURCHASE ORDER/
NO. DE COMMANDE: 04957



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	4	4	D2413B35335	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
3	3	3	D2414B35336	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
4	2	2	D2224B34970	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / O.A. Manager